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PROPERTY

D2332-041
Job Sheet 197765



388

Part No: D2332-041
Part Name: Lid Prop Assembly 6.69"

Part Weight: 0 lbs
Job Created: 7/16/19
Due Date: 8/12/19
Type: Stock
Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC
Ship Via:

Job Qty: 8 pcs
6.690 6389
Status: New
Priority: Medium
Job Tracking No:
Created By: Manon Dubois
Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	Small Fab - 1	8 pcs	8/12/19		0.32 2.50	Small Fab - 1		
						Small Fab - 2		
						Small Fab - 3		
						Small Fab - 4		
						Small Fab - 5		
						Small Fab - 6		
						Small Fab - 7		
110	Small Fab - Brake NC - B4B	8 pcs	8/12/19		0.25 0.91	Small Fab - Brake - 1 - B4B		BE B19-07-31 DAS 58 SEP 19 2019 RD
						Small Fab - Brake - 2 - B4B		
						Small Fab - Brake - 3 - B4B		
120	Small Fab - 2 - B4B	8 pcs	8/12/19		0.00 2.50	Small Fab - 1 - B4B		DAS 58 SEP 19 2019 RD
						Small Fab - 2 - B4B		
						Small Fab - 3 - B4B		
						Small Fab - 4 - B4B		
						Small Fab - 5 - B4B		
						Small Fab - 6 - B4B		
						Small Fab - 7 - B4B		
130	QC 5	8	8/12/19		0.00 0.00	QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		



Container No: S201905

Part: D2332 - 041
Job No: 197765
Serial No/Batch: S201905
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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Date: 09/23/19

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					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140 Large Fab - Welded Assy-2-B4B	8 pcs	8/12/19	0.00 1.99		Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	ML
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
150 QC 9	8 pcs	8/12/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	EL
					QC 9 - 9	
160 QC 5	8 pcs	8/12/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Small Fab - 3 - B4B	8 pcs	8/12/19	0.00 2.50		Small Fab - 1 - B4B	DAS 58 9-89 SEP 2 4 2019
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
180 QC 5	8 pcs	8/12/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS
					QC 5 - 40	SEP 24 2019 40
					QC 5 - 61	9-89
					QC 5 - 81	
190 Packaging 3-1 - Stock - B4B	8 pcs	8/12/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200 QC 21 - SA	8 pcs	8/12/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	SEP 24 2019 70
					QC 21 - SA - 53	9-89

Part Op 100 - (Small Fab) 1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332, 2- Cut D2332-11 using 1/2" S.S tubing
Descriptions: 7.735" long. 3- Deburr.
110 - (Punch ends and deburr as per dwg) Punch and form D2332-11 to lenght as per dwg D2332 using DT8012 (need 2 per ass'y)
120 - (Small Fab) 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no forein objects inside tube
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Weld per dwg A/R S.S. rod Batch: M138974) Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding***** S.S Rod batch: M138974
150 - (QC9- Inspect visual per QSI004- Fusion Welds)

ST345
ST303
ST264

- 160 - (QC5- Inspect part completeness to step on W/O)
- 170 - (Small Fab) 1- Tumble 2- Assemble as per dwg D2332
- 180 - (QC5- Inspect part completeness to step on W/O)
- 190 - (Identify as per dwg & Stock Location:_____)
- 200 - (QC21- Final Inspection - Work Order Release)

CROSS

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304R0.250	304 SS Round bar .250	.8000 ft (.1 ea)	100-Small Fab - 1	5175073
M304TR1.000W.049	304 Round Tube 1.00 X .049W	3.4400 ft (.43 ea)	100-Small Fab - 1	5200698
M304TR0.500W.035	304 Round Tube .500 X .035W	10 ft (1.25 ea)	110-Small Fab - Brake NC - B4B	5173356
AN4-4A	Bolt	8 Ea (1 ea)	170-Small Fab - 3 - B4B	5193116
MS21042L4	Nut	8 Ea (1 ea)	170-Small Fab - 3 - B4B	5214467
NAS1149D0416J	Washer	24 Ea (3 ea)	170-Small Fab - 3 - B4B	Am131511

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M304R0.250	1	12	0
	M304TR1.000W.049	3	11	0
110-Small Fab - Brake NC - B4B	M304TR0.500W.035	10	145	0
170-Small Fab - 3 - B4B	AN4-4A	8	74	0
	MS21042L4	8	3,020	0
	NAS1149D0416J	24	1,859	0

Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Lid Prop Assembly	5.000Inches ± 0.030	5.030 4.970	
2	Lid Prop Assembly	1.250Inches ± 0.010	1.260 1.240	
3	Lid Prop Assembly	6.690Inches ± 0.010	6.700 6.680	

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